



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D119-796-251
Job Sheet 171237



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP
REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP
REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/10/18	0.00	0.00	Start Up Crosstubes-1		AS APR 23 2018
130	Crosstubes	1 pcs		2/12/18	0.00	0.51	Crosstubes-1		AS APR 23 2018
140	QC	1 pcs		2/12/18	0.00	0.00	QC5		38 APR 23 2018
145	DC	1 pcs		2/12/18	0.00	0.00	DC		AS APR 23 2018
150	Packaging	1 pcs		2/12/18	0.00	0.00	Packaging3-1	LG050	AS APR 23 2018
160	QC21-FG	1 Ea		2/12/18	0.00	0.00	QC21		21 APR 23 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 002
150 - Identify and pack for shipping as per PPP D119-796-251

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 169273-B	D119-796-241 5018449	①	6	0
	D5123-3 5006028	④	338	0
	D5149-043 5039113	②	8	0
	MS21920-25 5024697	④	116	0

Part Specifications



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Container No: S063827



Part: D119-796-251

Job No: 171237

Serial No/Batch: S063827

Revision: E/F

Inspector:

Plex 2/7/18 8:11 AM Dart.Gagnon.Michelle

